

Date: Thursday, 2/22/2007 2:53:32 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X16")
Job Number	: 30800		
Estimate Number	: 12664		
P.O. Number	: N/A	Part Number	: D206559011
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Number	: D2435 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 30377	Material	: N/A
Written By	:	Due Date	: 3/13/2007 Qty: 5 Um: Each
Checked & Approved By	: <u>JA 07.02.23</u>		
Comment	: Est Rev: C 04.02.17 Blank size changed KJ/JLM Est Rev: D 07-01-02 Was K10007 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPPD206-559-011 CHG005

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.5491 sf(s)/Unit Total : 22.7456 sf(s)  
 blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: M103975

SA 07/04/03 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

SA 07.04.03 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.04.03 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/22/2007 2:53:32 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30800

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*7/2/07/04/05*

*(10)*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total : 8.3300 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050

Rubber Cushion

*~~B25013~~ 30872 ✓*

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 D2274

Radius Block

*B30518*

✓ 2 D2435(ref only)

Bearpaw

*B30800 ✓*

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 D2438

Clamp

*~~B25013~~ B30381*

*2X*

*18X B30631*

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 D2529

Washer

*B30382 ✓*

*7/4/5 SQ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:53:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30800

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M103585

M103039

M104072

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M102280

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M102929

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M103914

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

M103338

1 Paperwork package

7/4/5 S9

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/7/17 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Yes Date: 07/04/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:53:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30800

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-011

Location: Rev 12

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*Handwritten:* 2/24/07 (5)  
u 27.04.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



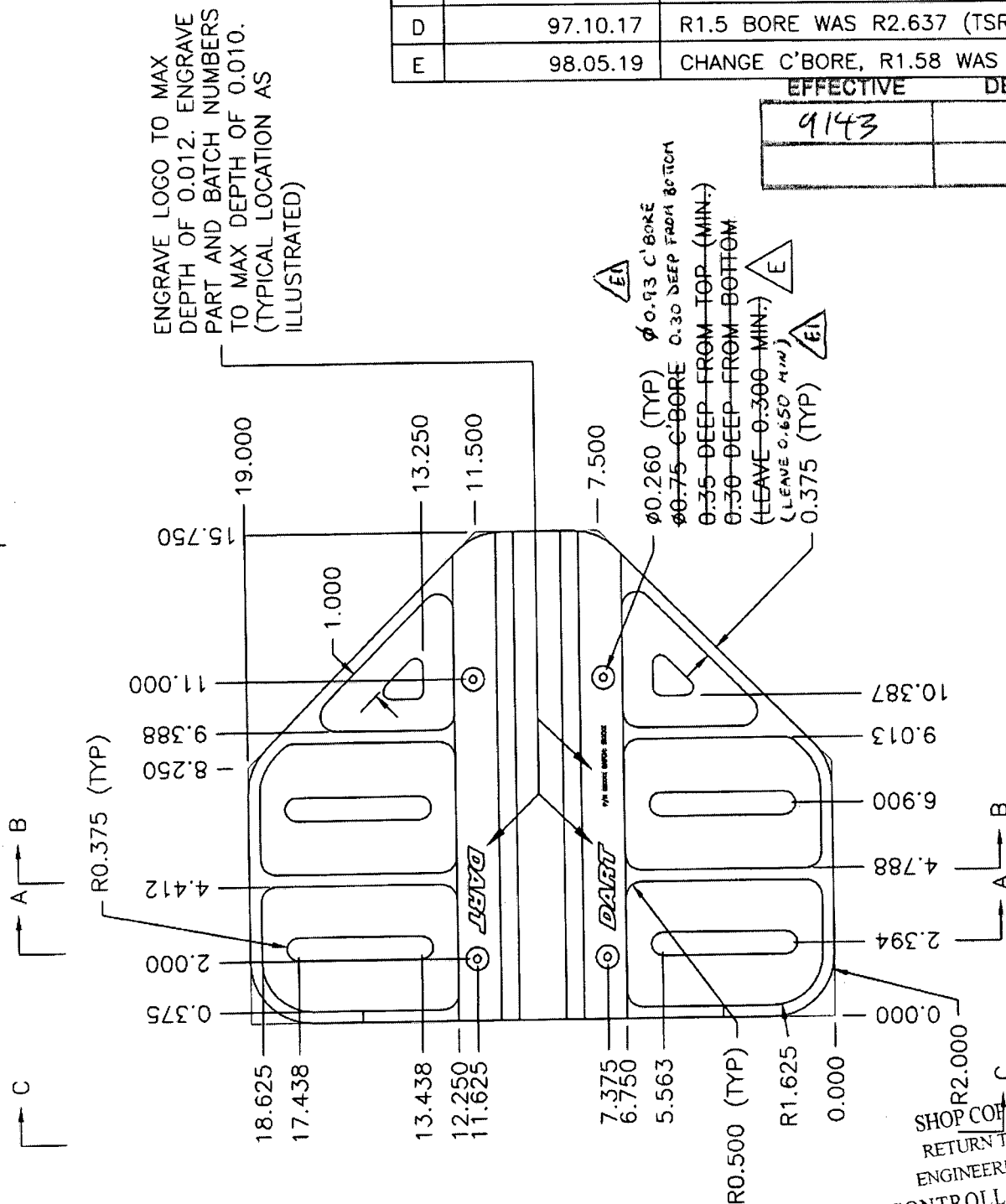


RELEASED  
43.06-17 KE

DESIGN <i>KE</i>		DRAWN BY <i>KE</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WID</i>		APPROVED <i>OS</i>		DRAWING NO. D2435 REV. E SHEET 1 OF 2	
DATE 98.05.19		TITLE BEARPAW		SCALE 1:5	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			

## EFFECTIVE DEOS

9143



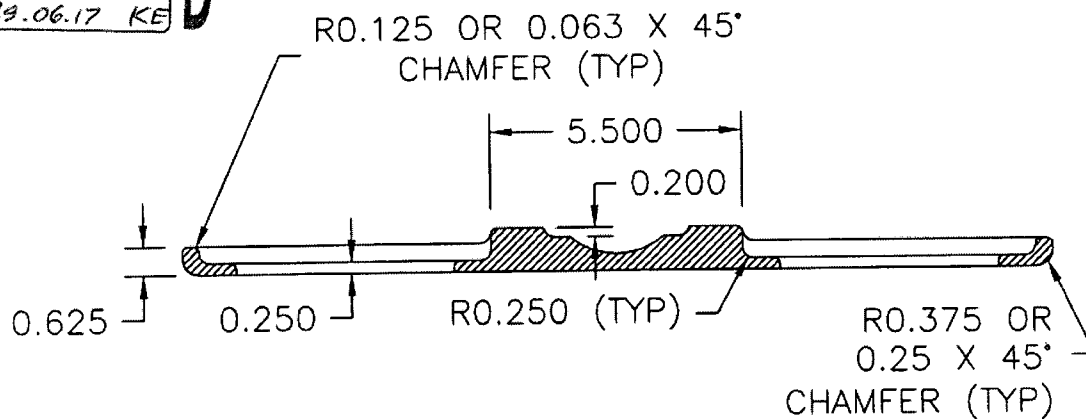
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30800

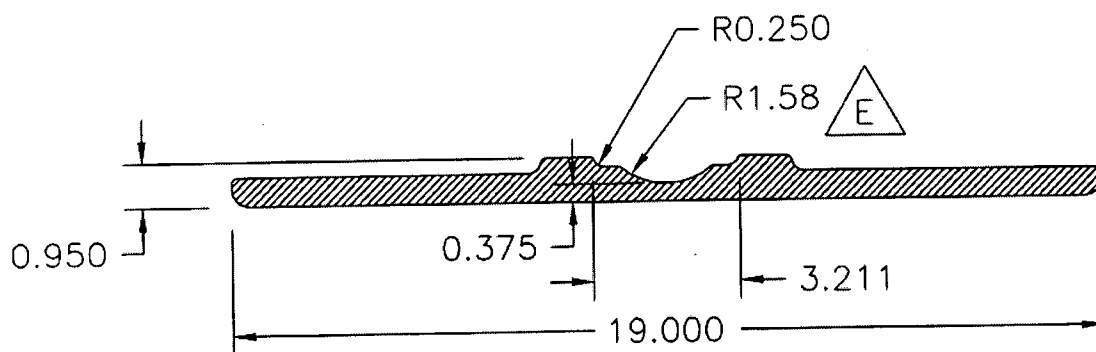


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DJS	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

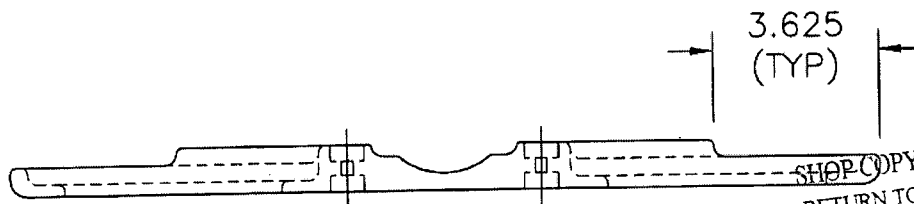
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30800

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30800
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2435
<b>Inspection Dwg:</b> D2435 <b>Rev:</b> E1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.06 x 45°	/			
B	5.500	+/-0.030	5.502	/			
C	0.200	+/-0.030	.188	/			
D	R0.250	+/-0.030	R.250	/			
E	0.250	+/-0.010	.255	/			
F	0.625	+/-0.030	.625	/			
G	0.25 x 45°	+/-0.030	.230 x 45°	/			
H	0.375	+/-0.010	.380	/			
I	19.000	+/-0.030	17.000	/			
J	0.950	+0.030/-0.010	.962	/			
K	Ø0.260	+0.005/-0.000	Ø.260	/			
L	Ø0.930	+/-0.030	Ø.930	/			
M	0.30	+0.030/-0.000	.308	/			
N	0.375	+/-0.030	.380	/			
O	7.375	+/-0.030	7.375	/			
P	4.250	+/-0.010	4.250	/			
Q	2.000	+/-0.030	2.000	/			
R	9.000	+/-0.010	9.000	/			
S	15.750	+/-0.030	15.750	/			

<b>Measured by:</b> SA	<b>Audited by:</b> JF	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07.04.04	<b>Date:</b> 07/04/04	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O K10007	KJ/RF	✱

Date: Thursday, 2/22/2007 2:53:32 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X16")  
 Job Number : 30800  
 Estimate Number : 12664  
 P.O. Number : Part Number : D206559011  
 This Issue : 2/22/2007 S.O. No. : Drawing Number : D2435 REV E1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 11 Type : MACHINED PARTS Drawing Revision : E1  
 Previous Run : 30377 Material :  
 Due Date : 3/13/2007 Qty: 5 Um: Each  
 Written By :  
 Checked & Approved By : 07.02.23  
 Comment : Est Rev: C 04.02.17 Blank size changed KJ/JLM  
 Est Rev: D 07-01-02 Was K10007 JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPPD206-559-011 CHG005

07.03.01

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 4.5491 sf(s)/Unit Total : 22.7456 sf(s)  
 blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch:

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

REFERENCE ONLY

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



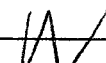
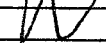
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Customer : CC-DAR01 Dart Aerospace Ltd.  
Job Number : 36674  
Estimate Number : 10804  
P.O. Number : *NA*  
This Issue : 09/01/2008 S.O. No. : *NA*  
Prsht Rev. : *NC*  
First Issue : *NA* Type : MACHINED PARTS  
Previous Run : 00015

Drawing Name : D206-559

Part Number : Z\_CUSTOM  
Drawing Number : ECN1101  
Project Number : *NA*  
Drawing Revision : *NA*  
Material : *NA*  
Due Date : 16/01/2008

Qty: 1 Um: Each

Written By :   
Checked & Approved By :   
Comment :

#### Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REMOVE FROM STOCK:

D206-559-011

*B34288 (10x) B30377 (x2) B30800 (x1) B32977 (x5)*

D206-559-013

*B32768 9x B30340 (2x)*

D206-559-021

*B28342 (x4)*

D206-559-023

*B25391 (x3) B34856 (x5)*

D206-559-025

*B28731 (x4)*

ADD NEW PAPERWORK JCAB STC: STC-90-TYO  
PER ECN 1101

RETURN TO STK

*8/1/10 SD (45x) AS*

2.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*208/01/11*

Job Completion



*W 28-01-11*